

Work Order ID 58359

May 4, 2010 10:49:33 AM



Page 1

Item ID: D3752-1

Accept



Setup

Start



Revision ID:

Item Name: Seat Frame

Stop



Start Date: 5/04/10 Start Qty: 4.00



Cust Item ID:

Required Date: 5/05/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3752

Rev C

100

0.00



10/05/04

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut sheet to required size

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240 FTime IN: 4:15 (10/05/04)Time OUT: 7:00 (10/05/04)

10/05/04

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Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Thermoform

Memo

0.00

BB
10/05/05
X3

Thermoforming Machine

Dwg. Rev. C
Folio Rev. C

120



QC2- Inspect parts off machine FAI/FAIB

0.00

BB
10/05/05
X3

QC

Quality Control

Memo

0.00

130



QC8- Inspect parts - second check

0.00

DR.
10/05/05
X3

QC

Quality Control

Memo

0.00

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

140

Operation
DescriptionHandThermo
Hand Finishing Thermoforming

Memo

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC2- Inspect parts off machine FAI/FAIB

0.00

QC
Quality Control

Memo

0.00

160



QC5- Inspect part completeness to step on W/O

0.00

QC
Quality Control



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

170



Packaging

Operation
Description

Identify as per dwg & Stock Location 251A

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10-5-7 S/3X

Packaging

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/12 AF

MF
10-5-7

Picklist Print

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Work Order ID: 58359



Parent Item: D3752-1



Parent Item Name: Seat Frame

Start Date: 5/04/10

Required Date: 5/05/10

Comments: IPP REV: A New Issue 08.06.03 DL verified by:DD

Start Qty: 4.00

Required Qty: 4.00

IPP Rev. B Dwg. Update 08/07/22 DL IPP Rev. C
Dwg. Update Shorter length 08/10/28 DL IPP Rev D Add Step 105
Dry Material 10/04/21 DL

MLEXS.125-F60029-04

Purchased No

100

sf

2,606.532

10.667



GE PLASTICS LEXAN SHEET

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	2606.5328	
111710	64	
112585	195	
114032	2347.5328	

+B

x3

DART AEROSPACE LTD	Work Order:	58359
Description: Seat Frame	Part Number:	D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			
Edges and corners such as thinness, cracks and sharp edges	✓			

Measured by: BS

Date: 10/05/05

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028	Min	.053	✓			
0.035	Min	.074	✓			
0.040	Min	.058	✓			
0.075	Min	.115	✓			
0.052	Min	.102	✓			
0.021	Min	.028	✓			
0.036	Min	.064	✓			

Measured by: BS

Date: 10/05/05

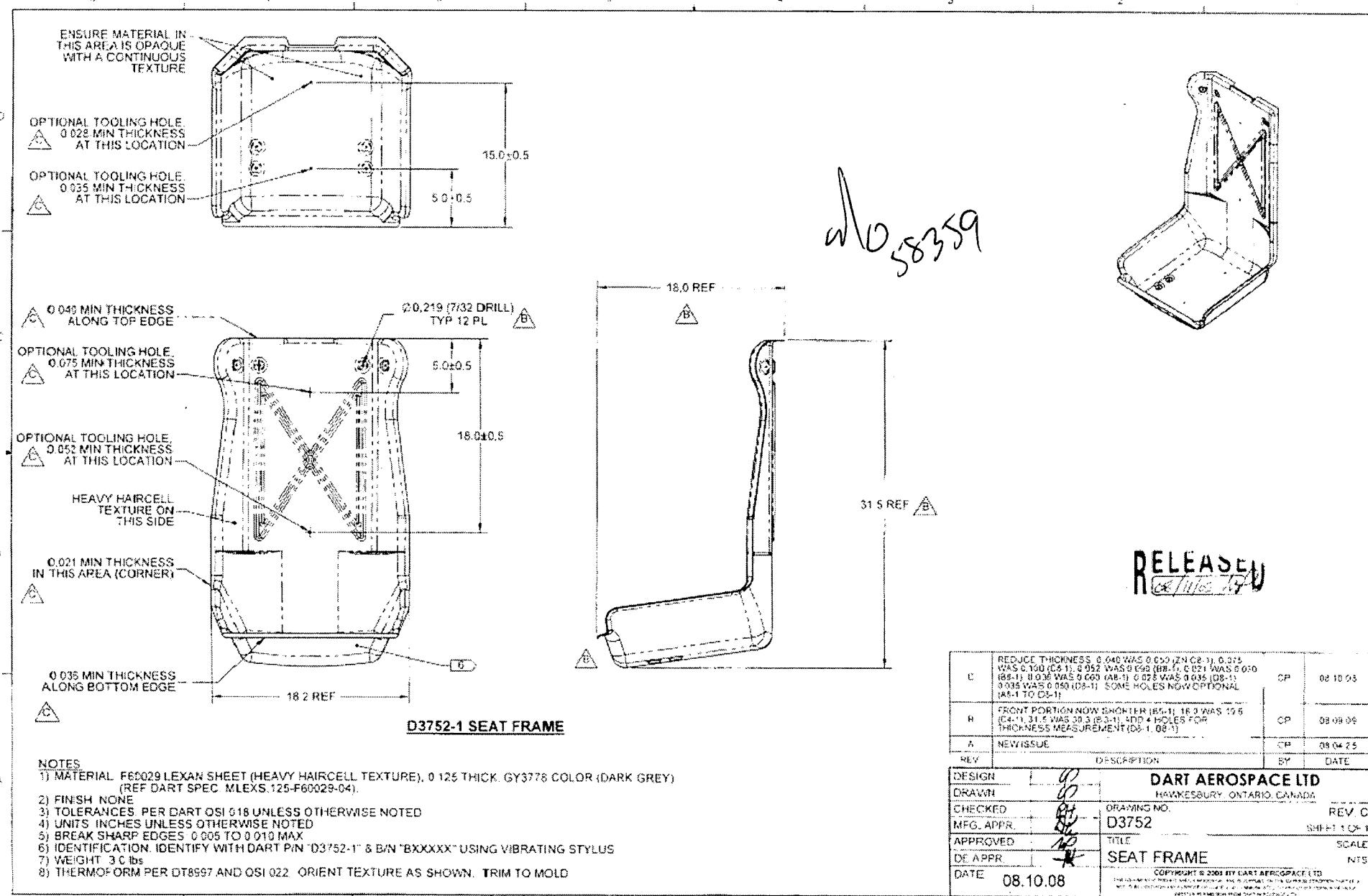
Audited by: JK

Date: 10/05/05

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	<u>JK</u>



NOTES
1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY)
(REF DART SPEC. MLEXS.125-F60029-04).
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3752-1" & B/N "XXXXXX" USING VIBRATING STYLUS
7) WEIGHT: 3 C lbs
8) THERMOFORM PER DT8997 AND OSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD